

Work Order ID: 56358

February 19, 2010 11:42:25 AM

PROTOTYPE

Item ID: D4010-1

Revision ID:

Item Name: Bearpaw

Start Date: 2/22/10

Start Qty: 2.00

Required Date: 2/23/10

Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4010

C

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4010-1 and Folio FTA067 using tool DT 9540

Dwg. Rev. C

Folio Rev. B

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

PROTOTYPE

Page 1

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

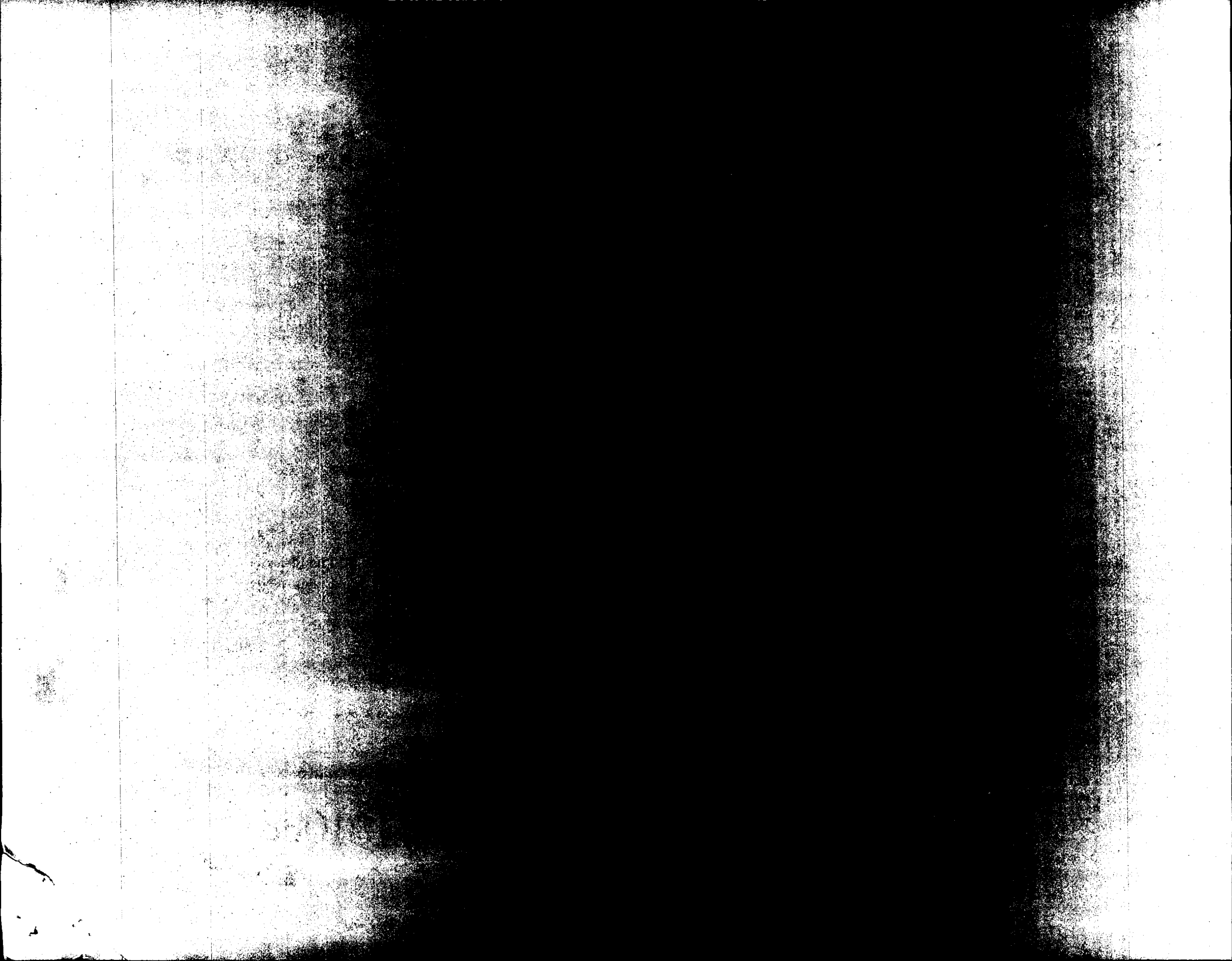
Stop

PROTOTYPE

BB 10/02/19
(X4)

BB 10/02/22
(X4)

BB 10/02/22
(X4)



Work Order ID 56358

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Item ID: D4010-1

Accept



Setup Start



Revision ID:

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Item Name: Bearpaw

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

140



Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

0.00

Memo

0.00

1-Trim & Drill to Finished Dimensions as per dwg D4010-1

2- Use wearplate jig DT9542 to transfer drill holes in bearpaw as per dwg and use 0.375" unibite to open holes to finish size.

3- Deburr

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

10/02/22

10/02/23
(X4)

10/02/23
(X4)

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Item ID: D4010-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 2/22/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/23/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

PTO →

170

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

SEE NGR WB FOR DISPOSITION
10/04/15

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

R00324 APR

POSITIVE RECALL

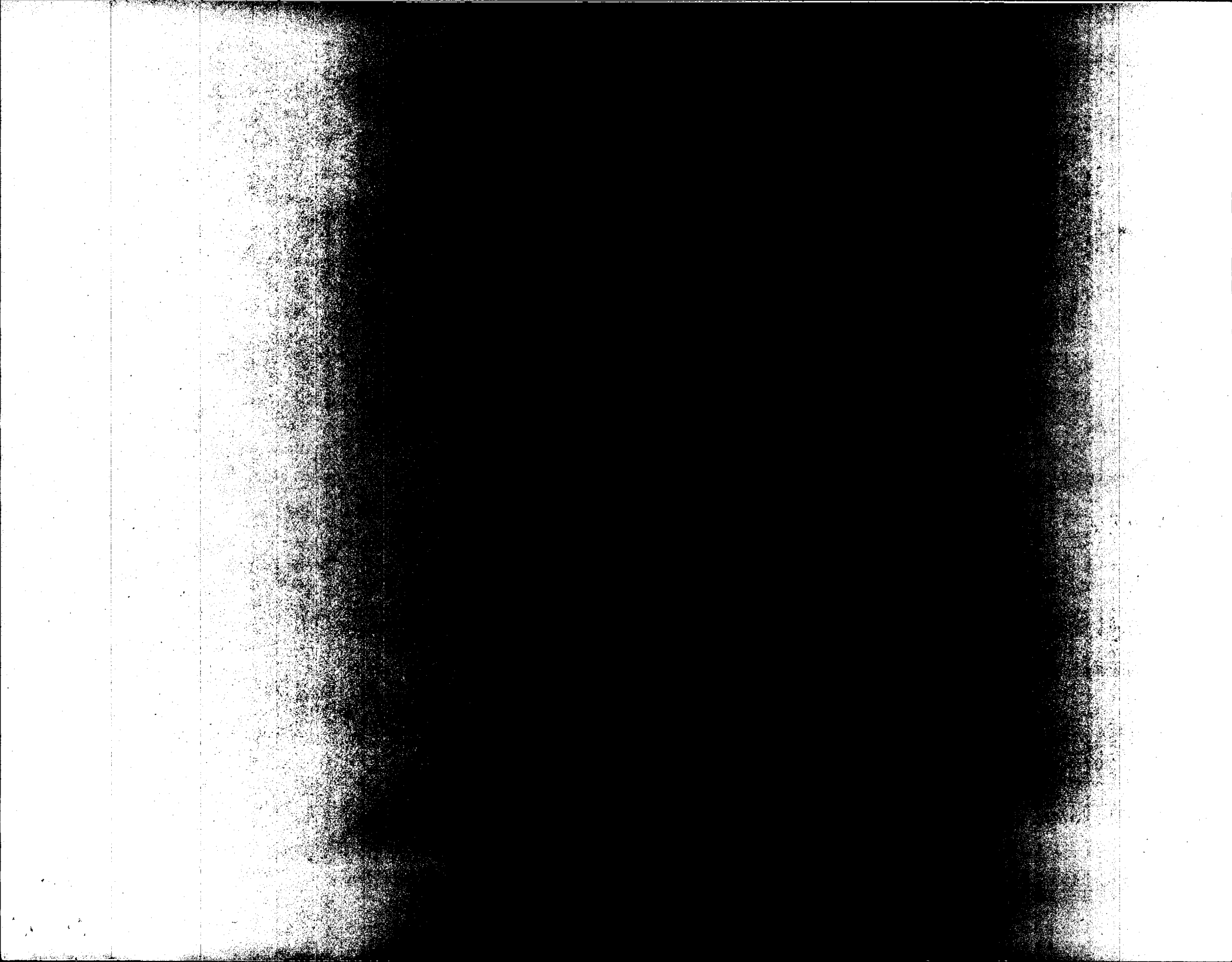
EFFECTIVE

RELEASED

AUTH


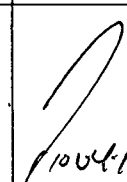

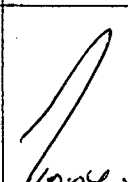
DATE

PS 10 4 15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4010-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 4 Date: 100406
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>56358</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/07	168	REVISED PROCESS & MOLD SCRAP 4 PARTS THAT DO NOT CONFORM TO NEW PROCESS OR CURRENT MOLD CONFIGURATION.		SCRAP 4 parts. DO NOT REPLACE.	OK. 10/04/07			

NOTE: Date & initial all entries

Picklist Print

February 19, 2010 11:42:24 AM

Page 1

Work Order ID: 56358



Parent Item: D4010-1



Parent Item Name: Bearpaw

Start Date: 2/22/10

Required Date: 2/23/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NEALXTRAB-S-300		Purchased	No			100	sf	795.4833	149558			



Alextra ET 0.300 sheet



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	795.4833	
	795.4833	

DEGAL

10/02/19
XY

DART AEROSPACE LTD		Work Order: 5638
Description: D 4010-1 DEARAW		Part Number: D 4010-1
Inspection Dwg: D 4010 Rev: <		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

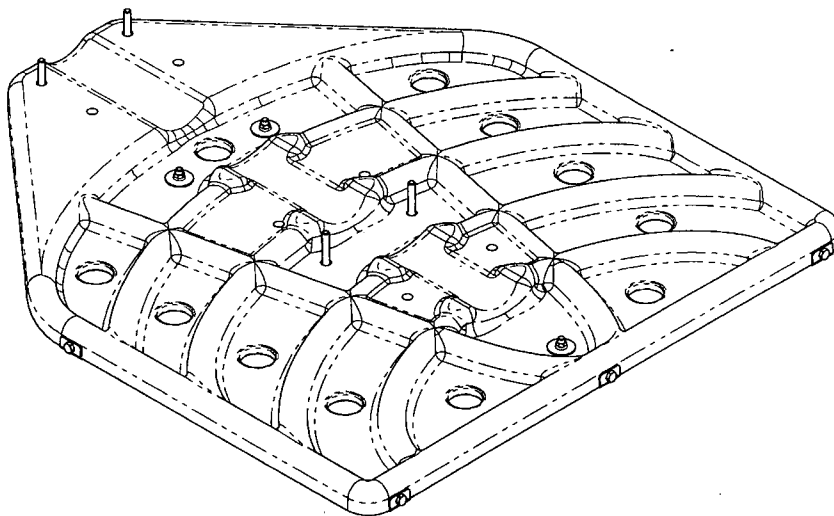
Measured by: <u>JB</u>	Date: 10/02/23
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.175	Min	0.225	✓			
0.210	Min	0.247	✓			
27.00	± .25	26.710	✓			
2.34	± .25	2.25	✓			
23.25		23.25	✓			

Measured by: <u>JB</u>	Date: 10/02/23
Audited by: <u>Whe</u>	Date: 10/02/23
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



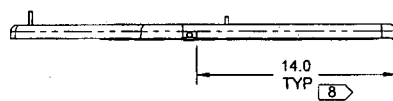
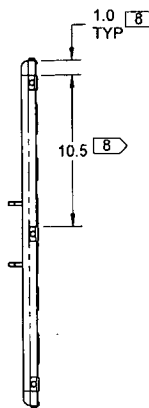
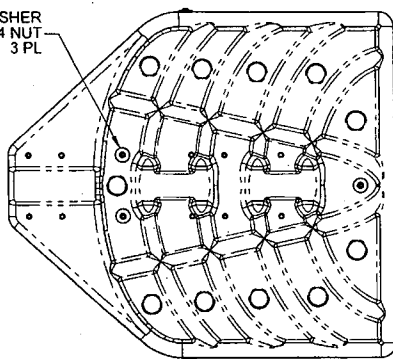
D4010-041 BEARPAW ASSEMBLY (407)

WLB
56358

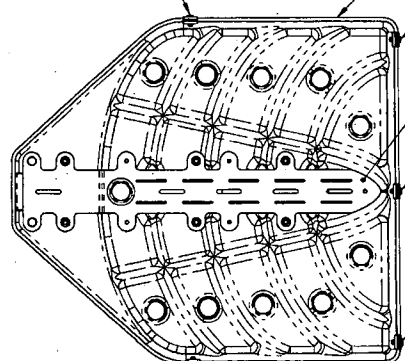
RELEASED
2009-11-26
MP

C	OPTIMIZED DESIGN BASED ON FUNCTIONALITY AND TO EASE MANUFACTURING	MB	09.11.10
B	REDESIGNED, ADDED PROVISIONS FOR COMPATIBILITY WITH OEM SKIDTUBES/SADDLES; REDEFINED SOME TOLERANCE	MB	09.11.02
A	NEW ISSUE	MB	09.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>LA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>LA</i>		
CHECKED	<i>ALS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>AS</i>	D4010	SHEET 1 OF 3
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	BEARPAW (407)	NTS
DATE	09.11.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

D3456-1 WASHER
MS21043-4 NUT
3 PL



AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT



D4010-1
BEARPAW

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4013-041 WEARPLATE
ASSEMBLY

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

AN3C5A BOLT
D4015-041 WEARBAR
MS21043-3 NUT

D4010-041 BEARPAW ASSEMBLY (407)

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4010-041	BEARPAW ASSEMBLY (407)
3	3	D3456-1	WASHER
4	1	D4010-1	BEARPAW
5	1	D4013-041	WEARPLATE ASSEMBLY
6	5	D4015-041	WEARBAR
21	5	AN3C5A	BOLT
22	5	MS21043-3	NUT
23	3	MS21043-4	NUT

no 56358

RELEASED
2009-11-24

- D4010-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 9.41 lbs
 - 8) LOCATE D4015-041 (ITEM 5) AS SHOWN AND TRANSFER DRILL Ø0.191" HOLE FROM D4015-041 TO D4010-1 BEARPAW AND FASTEN USING PRESCRIBED HARDWARE.
 - 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	ALS	DRAWING NO. D4010 REV. C
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE BEARPAW (407) SCALE NTS
DE APPR.		
DATE	09.11.10	

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